

Date: Tuesday, 07/04/2009 10:16:54 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP STRUT
Job Number : 46943	
Estimate Number : 11938	
P.O. Number :	Part Number : D2017123
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D2017 REV E1 F E
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : SMALL /MED FAB	Drawing Revision : E1 F
Previous Run : 43576	Material :
Written By :	Due Date : 22/04/2009 Qty: 4 Um: Each
Checked & Approved By : JUL 09.04.07	
Comment : Est D 02.06.19 Update processes (Ref. ECN 435) KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304TR0750W049	304 RD Tube .750 x .049W
-----	----------------	--------------------------

**Comment:** Qty.: 1.1550 f(s)/Unit Total : 4.6200 f(s)

Punch tube type 304-2B, 3/4" Ø. X .049" wall to length per Dwg. D2017 & spec control D2638

Batch No. M111331

SB 09/04/27

(4)

Deburr

M-1 09/04/28 (4X)

2.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP

S 02/04/28 (4)

3.0	POWDER COATING	POWDER COATING
-----	----------------	----------------

**Comment:** POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 7:15OVEN TEMPERATURE: 400°FINISH TIME: 7:45

cmo/bf

09/04/29 (4)

4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---

**Comment:** INSPECT POWDER COAT

F 09/04/29 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:16:54 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP STRUT

Job Number: 46943

Part Number: D2017123

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 250

SS 09/04/30 X4

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/30

Job Completion



MF 09-04-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

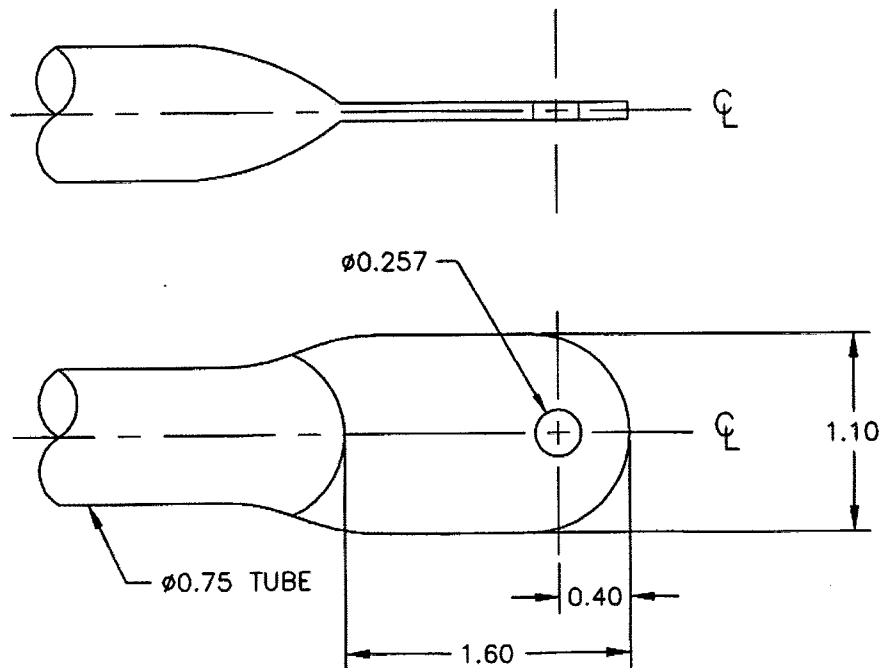
NOTE: Date & initial all entries



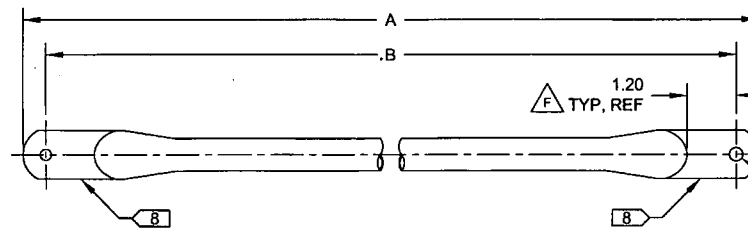
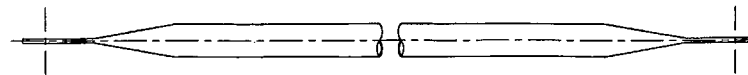
DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MM	APPROVED KE	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
48/07/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46943



Ø0.312
WIDEN HOLE
AFTER PUNCHING
1 END ONLY

8
EXCEPT
AS SHOWN

D2017-XXX STEP STRUT

PART NUMBER	A	B
D2017-101	17.73	16.93
D2017-103	18.74	17.94
D2017-113	20.50	19.70

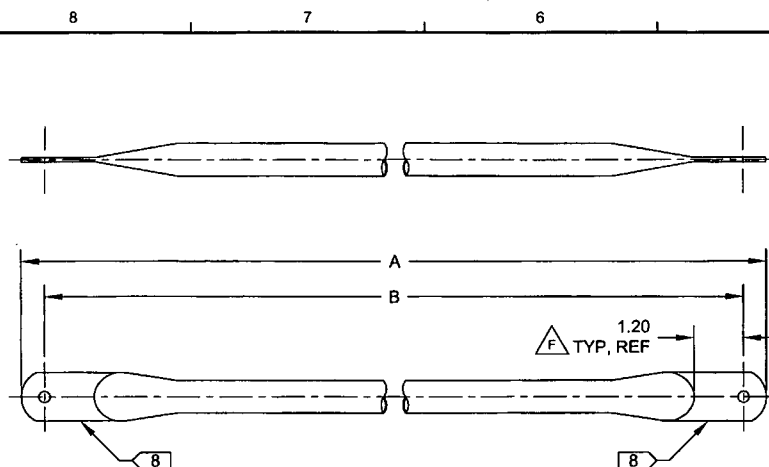
RELEASED
09/04/16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 11000

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.750 x 0.049 WALL
REF. DART SPEC M304TR0.750W.049
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2017-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) PUNCH ENDS PER SPEC CONTROL DRAWING D2638.

F	DRAWING TRANSFERRED TO "B" FORMAT AND TO CURRENT STANDARDS. REDRAWN FOR CLARITY 1.20 REF DIM ADDED. SEE PAR 09-002 FOR DETAILS.	AJS	09.03.06
E	ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897) ADD FINISH (INCOPORATE E1)	CP	02.03.22
D	ADDED PARTS	BW	96.03.28
C	ADDED PARTS	BW	95.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2017	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP STRUTS	NTS
DATE	09.03.06	<small> COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS TO BE RELEASED ONLY ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE (AS SET FORTH IN THE ATTACHED RELEASE AGREEMENT) WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. </small>	



D2017-XXX STEP STRUT

PART NUMBER	A	B
D2017-105	14.95	14.15
D2017-107	15.61	14.81
D2017-109	13.93	13.13
D2017-111	15.30	14.50
D2017-115	12.42	11.62
D2017-117	13.86	13.06
D2017-121	12.30	11.50
D2017-123	12.92	12.12
D2017-125	19.55	18.75
D2017-127	20.30	19.50
D2017-129	31.43	30.63
D2017-131	19.68	18.88
D2017-201	21.31	20.51
D2017-203	16.39	15.59
D2017-205	16.53	15.73
D2017-207	13.85	13.05
D2017-209	15.64	15.33
D2017-211	15.67	14.87
D2017-213	15.82	15.02
D2017-215	16.47	15.67
D2017-217	16.70	15.90
D2017-219	13.65	12.85
D2017-221	13.58	12.78
D2017-223	12.95	12.15
D2017-225	13.99	13.19
D2017-227	30.67	29.87
D2017-133	30.66	29.86

SHOP COPY

RETURN TO

ENGINEERING

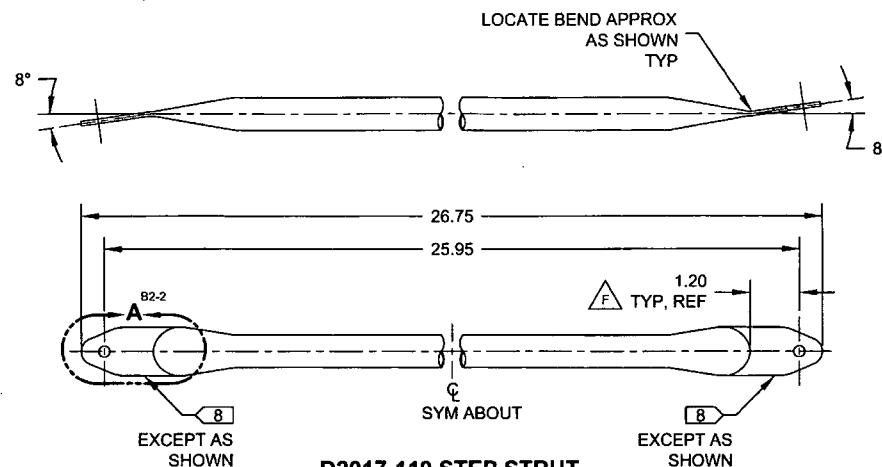
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

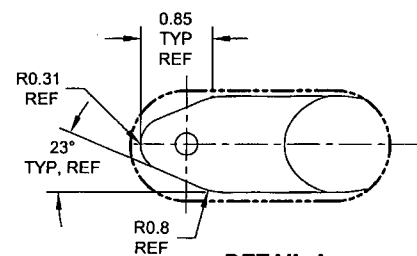
WITHOUT NOTICE

WORK ORDER

NO. 110843



D2017-119 STEP STRUT
(SHOWN PRIOR TO BENDING)



DETAIL A D4-2
TRIM AFTER PUNCHING PER DT8360
SCALE 2X

RELEASED
09/04/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2017	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP STRUTS	NTS
DATE	09.03.06	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			